Work Order ID 59478 <i>Friday, June 04, 2010 2:46:53 PM</i>											Page
Item ID: Revision ID:	D3999-7			Accept				S	Setup Stai	rt	
Item Name:		t Qty: 2.00 d Qty: 2.00			Cust Item l Customer:	D:			Sto	P 	
Approvals:	Process Plan:	H	Date: / <i>D-(a-0)</i> Date:	7 Tooling: SPC (Y/N):		ate:		F	Run Stai Stop		
Sequence ID/ Work Center ID		iption		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3999	Revision N A	[br									
100 Waterjet		Memo		0.00					10-6-1	۵	

FLOW CNC Waterjet

Memo

1-Cut as per Dwg
Dwg Rev:
Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1310-6-10

Quality Control

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Ca	tegory:	NCI	R: Yes	No DQA :		Date:				
Resolution:			Disposit	ion:	QA	N/C Cld	sed:		Date:				
NCR:			WORK OR	DER NON-CONFO	RMANCE	(NCR)						
DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Description		Section B	Sign & Verificat				Approval			
		Collon A	Chief Eng	Chief Eng		Date	Section	- C	Chief Eng	QC Inspector			
										,			

Work Order ID 59478

Friday, June 04, 2010 2:46:53 PM



Page 2

Item ID:

D3999-7

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Corner

Required Date: 6/11/2010

QC:

6/4/2010

Start Qty: 2.00

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: **Date:** ____ Start

Stop

Stop



Sequence ID/

Work Center ID

120

QC

Operation

Description

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Run

Qty

Reject Reject Number

Insp. Stamp

Quality Control

Memo

QC8- Inspect parts - second check

ک ریانداری

. . -

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/14 A

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No: PAR #:													
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DATE	STEP	Description of NC Section A	Corrective Action Des				Verification		Approval	Approval			
		Section A	Chief Eng	Chief Eng		Date	Section	С	Chief Eng	QC Inspector			
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NOTE: D										•			

Picklist Print

Friday, June 04, 2010 2:46:57 PM

Work Order ID: 59478

Parent Item:

Comments:

D3999-7

Parent Item Name:

Corner

IPP rev A 09.12.16 new issue Prelim EC verified by DD IPP rev B

10.05.10 ecn 10-562 EC verified by:DD

Start Date: 6/4/2010

Required Date: 6/11/2010

Start Qty: 2.00

Required Qty: 2.00

1310-6- V

Component Item ID/ Item Name

M6061T6S.080

Replacement Mfg/ Item ID Purch

Purchased

Primary Bin Item Location No

Last Location Route Seq ID 100

Unit of Measure Hand sf

Qty on 157.4419 Qty per Kit Total 0.011

Otv Issued 0.023158

Qty

Date **Issued**

Status

Page 1

6061-T6 .080 Sheet

Location

MAT21

114351

Loc Qty 157.44193 Loc Code

114351

113438

2.7512 154.69073

Dart Aerosp	ace Ltd
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W/O:		WORK ORDER CHANGES											
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DART AEROSPACE LTD	Work Order:	<u> ५५५७</u> ८
DART ALROOF ACE 275		
Description: CONES	Part Number:	D3949-7
Inspection Dwg:D3999-7 Rev: A		Page 1 of 1

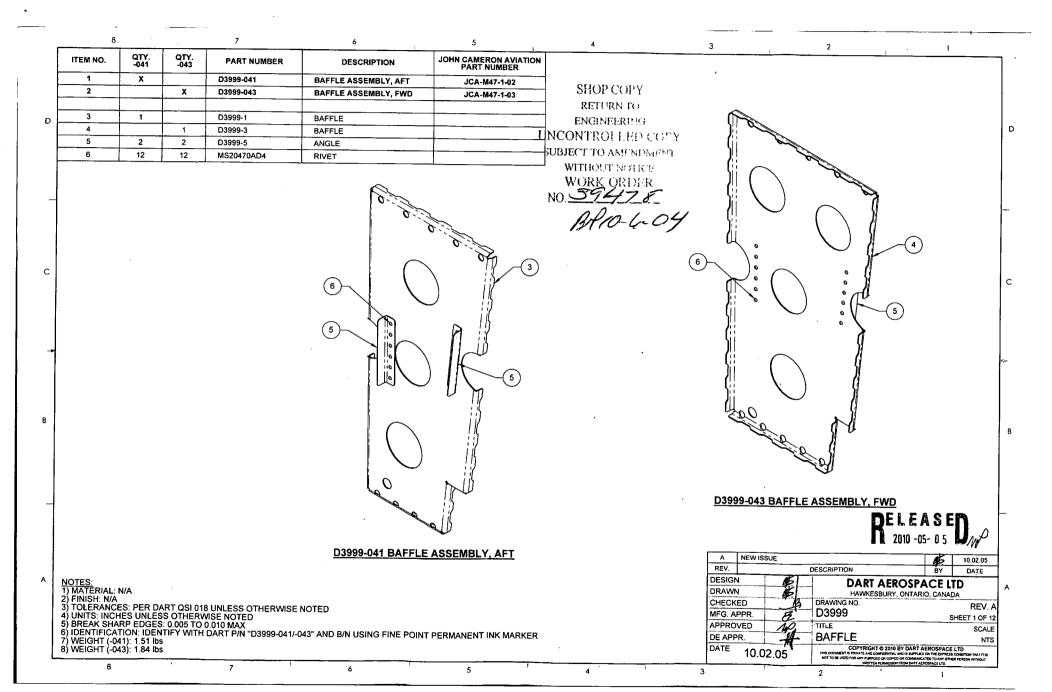
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

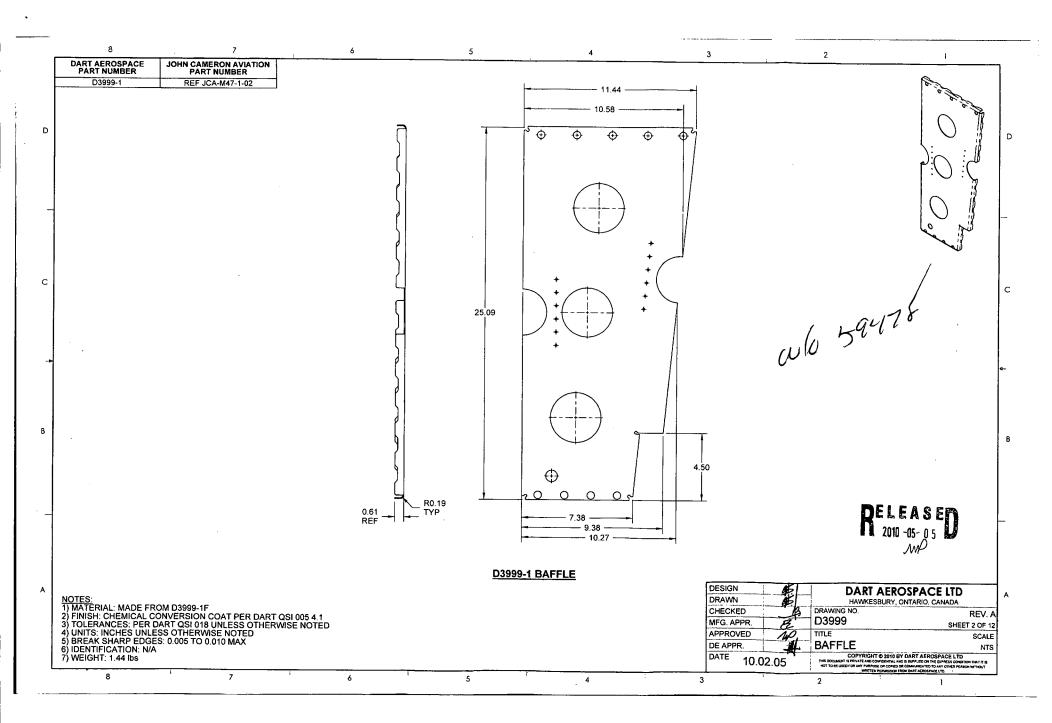
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Date: 10-6-10	Date: 10/66/10	Date:	N/A

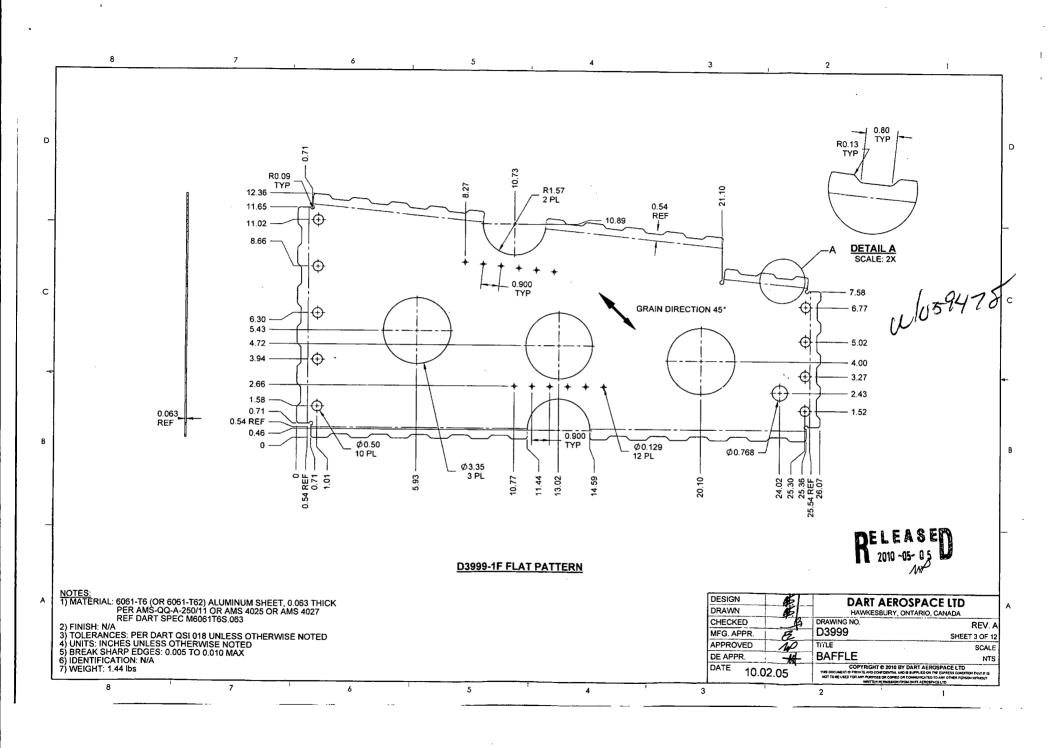
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Rev	Date	Change	1/ 1/ 11 M	1
Α		New Issue	KJ/JLM	1



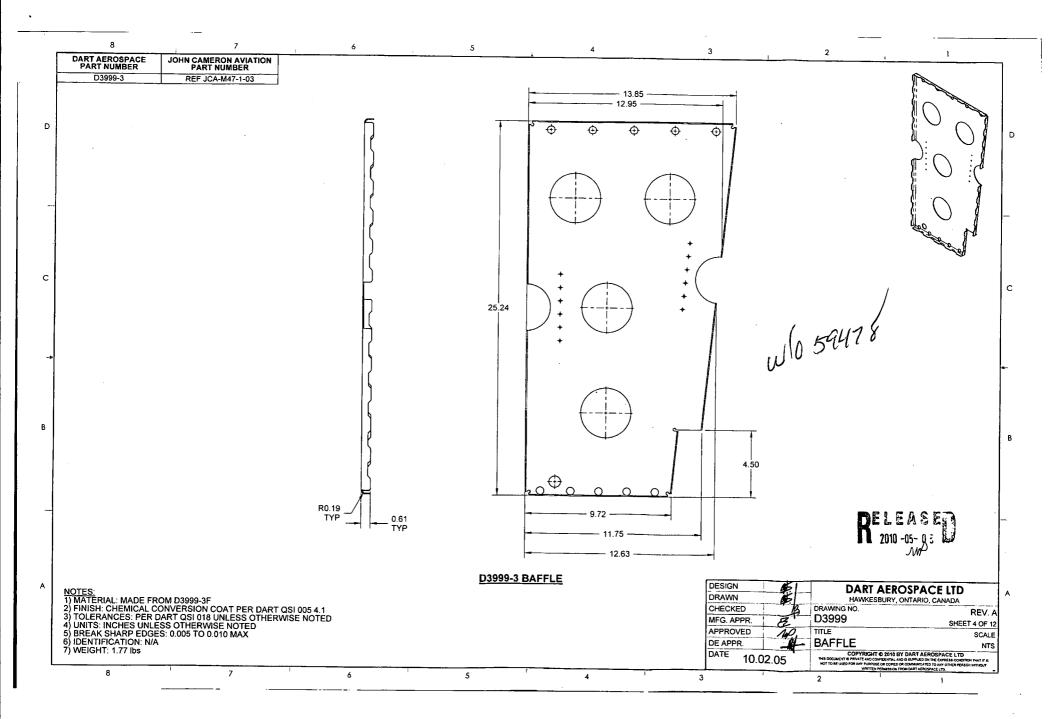
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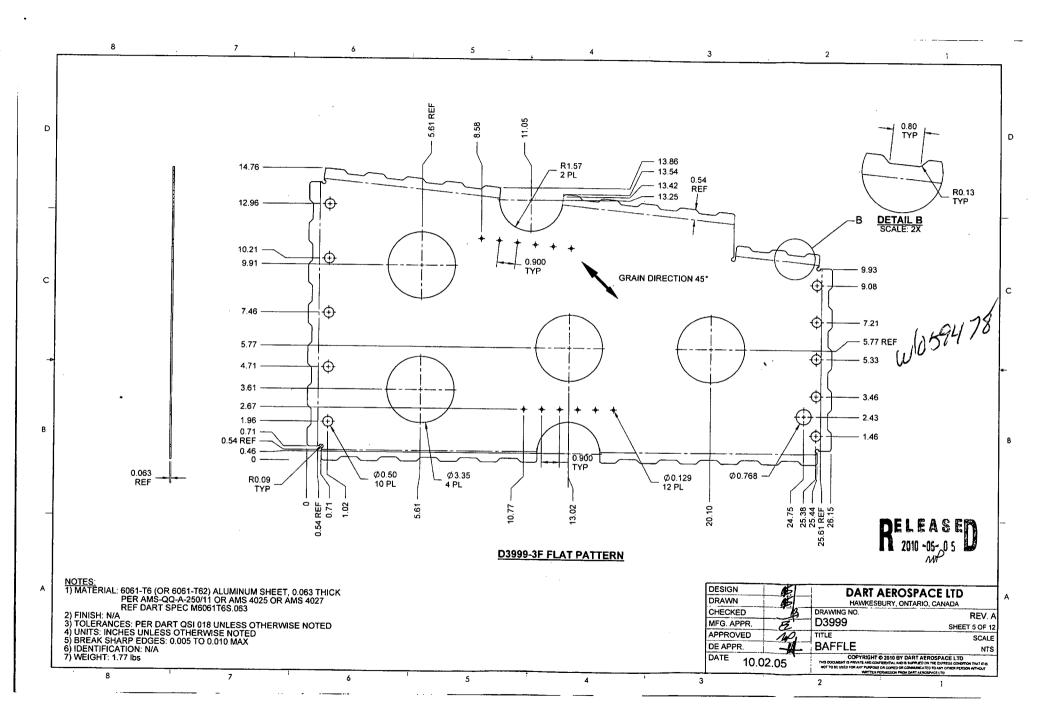
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		Section A	Chief Eng	Action Description Chief Eng					on C	QC Inspector			
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		Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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5 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER REF JCA-M47-1-02 REF JCA-M47-1-03 D3999-5 D D 0.83 ulu 59478 5.50 REF 0.83 REF R0.12 -В **D3999-5 ANGLE** DESIGN NOTES:
1) MATERIAL: MADE FROM D3999-5F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 6 OF 12 APPROVED TITLE SCALE **BAFFLE** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD

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3 D wlo saun's R0.20 С TYP BEND LINE-GRAIN DIRECTION 1.55 0.78 REF 0.40 TYP Ø0.129 6 PL 0.50 TYP 0.900 REF TYP

D3999-5F FLAT PATTERN

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.040

7

2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 7 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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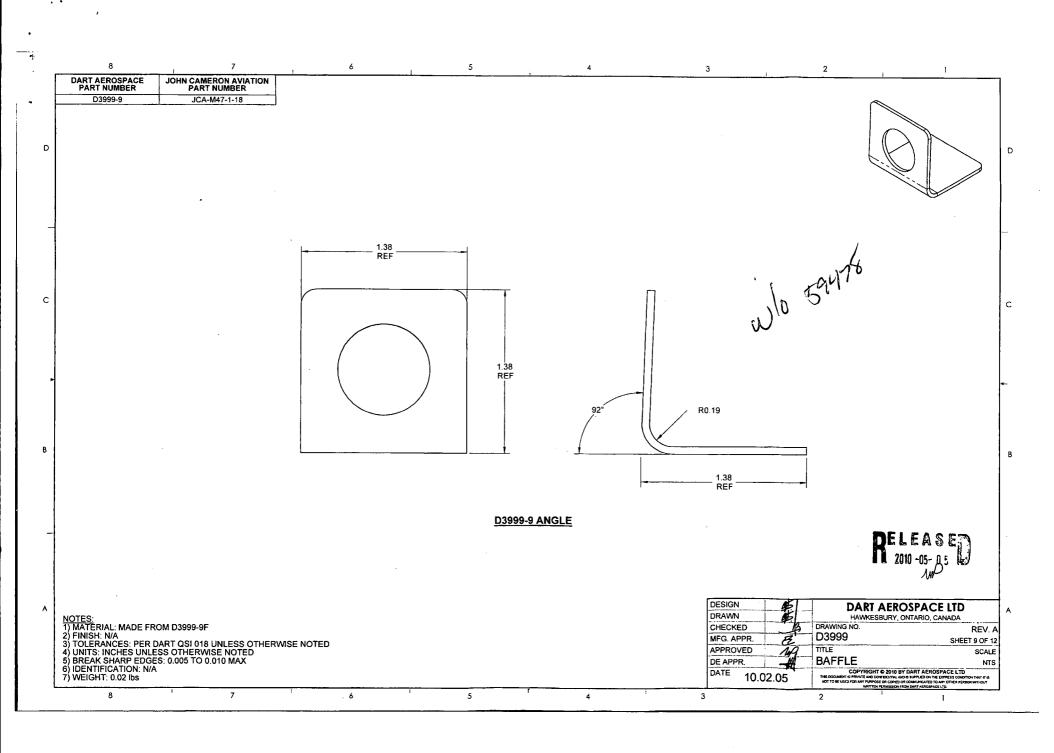
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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA: _	Date: _	
	Res	solution:	Dispositio	n:	_ QA: N/C C	losed:	Date: _	
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DATE	STEP	Description of NC			ion B	Verification	n Approval	Approval
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C		QC Inspector
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DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-7 JCA-M47-1-17 D D 0 - 0.59 0.59 С С 1.77 Ø0.157 В 0.080 REF **D3999-7 CORNER** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.080 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA REF DART SPEC M6061T6S.080
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 8 OF 12 APPROVED TITLE SCALE **BAFFLE** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			WC	RK ORDER CHANG	iES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No Do	QA:	Date: _	
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DATE	STEP	Description of NC			ion B	Veri	fication	Approval	Approval
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DATE	STEP	Description of NC	Initial		ection B	Cian 9	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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5 . D - 2.59 Ø0.768 С W 59478 GRAIN DIRECTION - **E** 1.38 BEND LINE 0.68 0.063 REF 1.29 REF **D3999-9F FLAT PATTERN** RELEASED 2010 -05- 0.5 NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S0.063 DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN REF DART SPEC M6061T6S0.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.02 lbs CHECKED DRAWING NO.

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REV. A D3999 MFG. APPR. SHEET 10 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS DATE 10.02.05 COPYRIGHT © 2010 BY DART AEROSPACE LTD
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W/O:			W	ORK ORDER CHANG	ES	***				
DATE	STEP	PRO	OCEDURE CHA	NGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector

5 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D3999-11 JCA-M47-1-19 D 1.00 REF 0.62 R0.20 **D3999-11 EARTH TAB**

DESIGN DART AEROSPACE LTD NOTES:
1) MATERIAL: MADE FROM D3999-11F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D3999 MFG. APPR. SHEET 11 OF 12 APPROVED TITLE SCALE **BAFFLE** DE APPR. NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD

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Dart Aerospa	ace Ltd
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W/O:		WORK ORDER CHANGES									
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			Chief Eng	Action Description Chief Eng	Da		Section C	Chief Eng	QC Inspector		

7 3 Ď D 1.32 -Ø0.125 2 PL 0.56 1.00 GRAIN DIRECTION 0.22 TYP R0.20 0.25 0.063 TYP REF В BEND LINE 0.52 REF **D3999-11F FLAT PATTERN** NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF DART SPEC M6061T6S.063 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.01 lbs DRAWING NO. CHECKED REV. A D3999 MFG. APPR. SHEET 12 OF 12 APPROVED TITLE SCALE BAFFLE DE APPR. NTS COPYRIGHT & 2010 BY DART AEROSPACE LTD
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Dart Aerospace Ltd

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